

A-B-C-D split

Date: Tuesday, 12/09/2006 11:43:54 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28491 - B
Estimate Number : 10377
P.O. Number : N/A
This Issue : 12/09/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 12/09/2006 Type : PURCHASED PARTS
Previous Run : 28490
Written By :
Checked & Approved By :
Comment : Est. D 05.03.21 Removed Bending procedures KJ/JLM

Drawing Name : AFT CROSSTUBE
Part Number : D2890
Drawing Number : D2890 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 30/09/2006
Qty: 42 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6008180 Crosstube extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
1	D6008-180	Crosstube extrusion	22534 RT 06-09-12

2.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
ACID ETCH & ALODINE

RT 06-09-12

3.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

NP 6-9-13 - (2)
6-9-14 - (2) (4) (P10)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

206.00.02



5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1




Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

W N/A see DWG. 546

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-02	3.0	W/O split for 2 x-tubes (Rush) 2 tubes remain.		06-10-2	(2)		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/10/23
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/09/2006 11:43:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 28491

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 06.10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

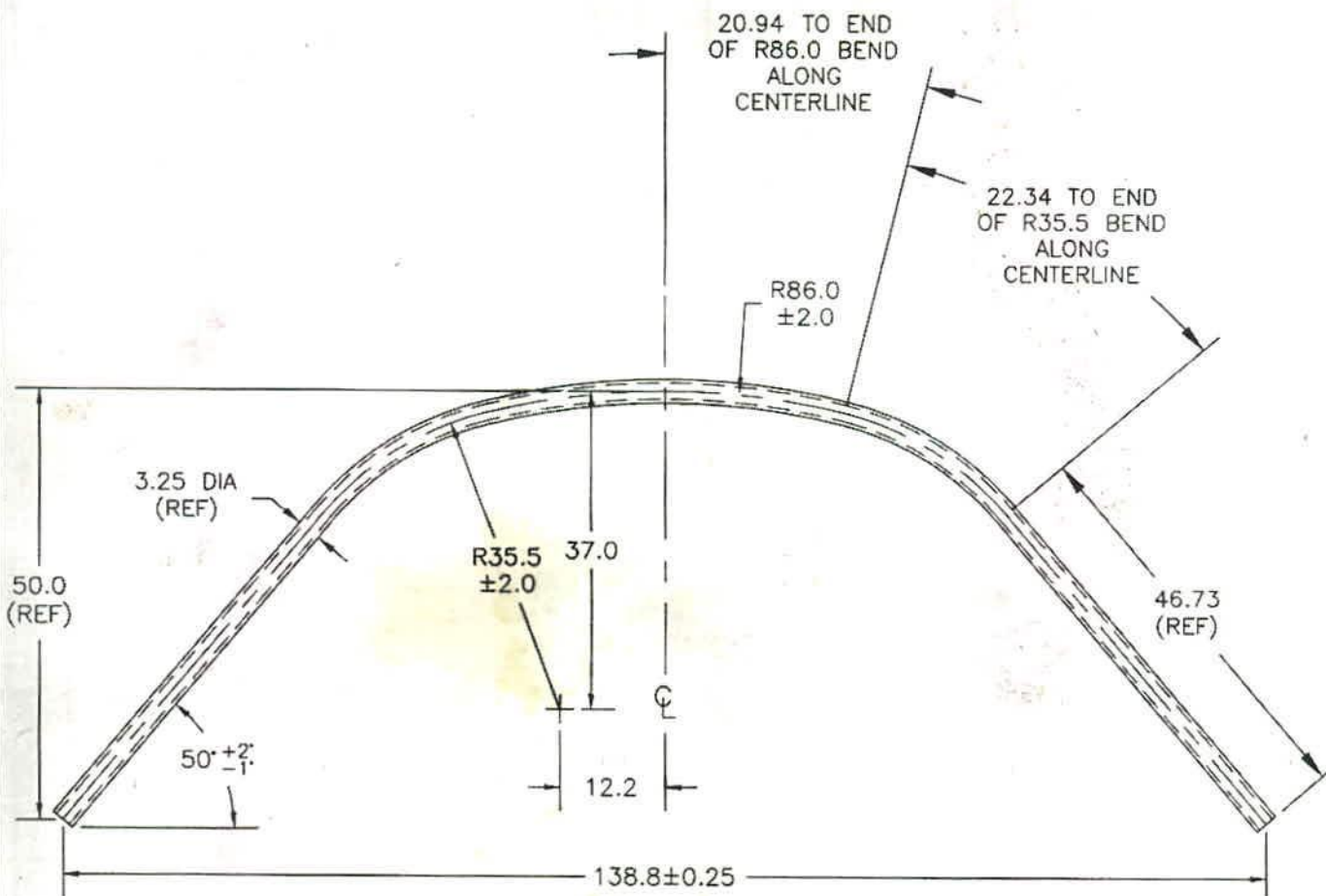
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**REFERENCE ONLY****RELEASED**
02-10-28

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2890
DATE 02.10.18		TITLE AFT CROSS TUBE
	A 99.05.21	NEW ISSUE
	B 02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES
		REV. B
		SHEET 1 OF 1
		SCALE 1:20

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\phi 3.25$ OD \times 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

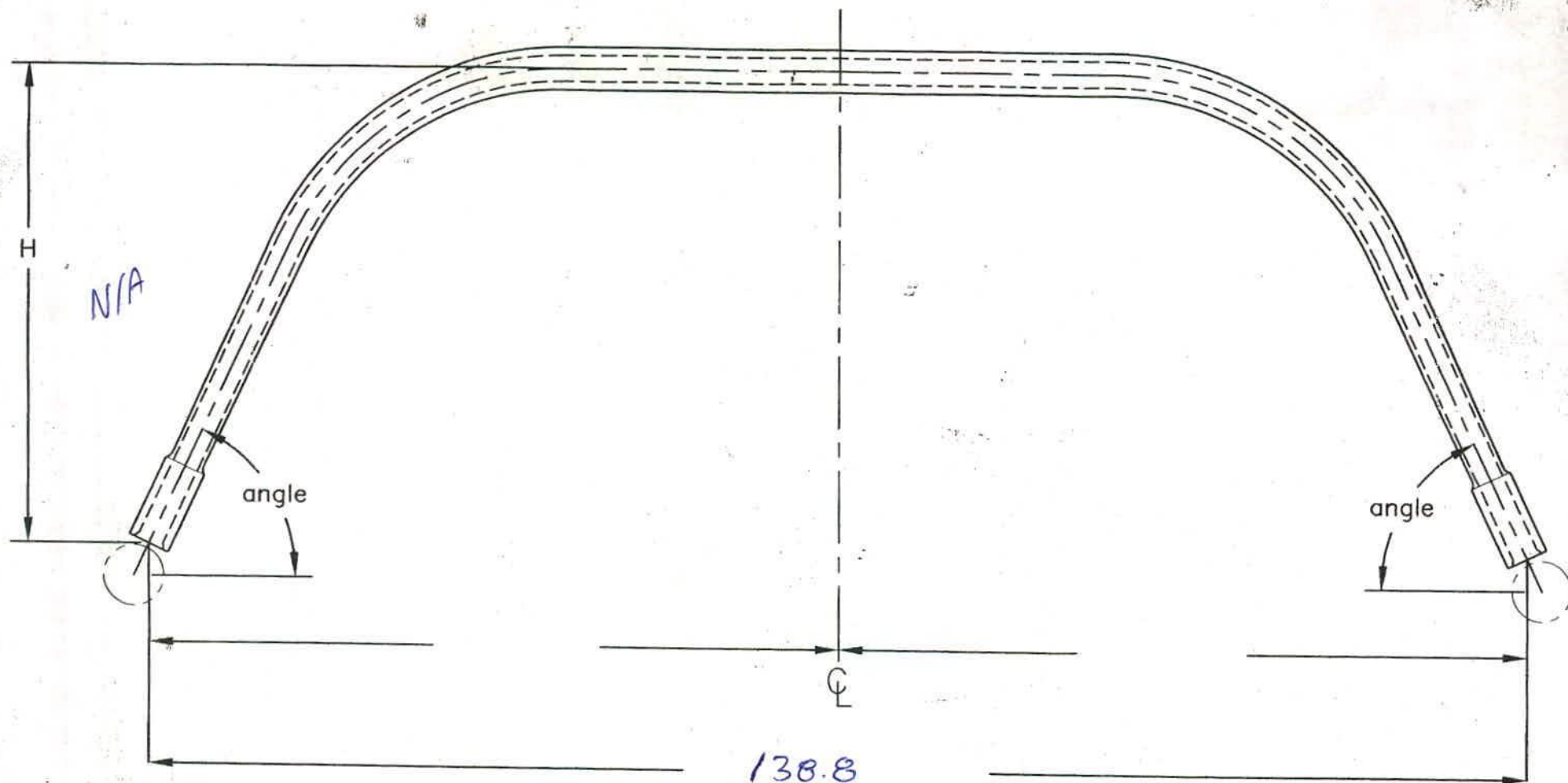
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DATE: 06-10-02

DESCRIPTION: 2890

BATCH NO: 828491 Tube B

DRAWING: 2890 Rev. B

H: 50.0 N/A

1/2 SPAN: N/A

TOTAL SPAN: 138.8

ANGLE: 50⁺²₋₁